

Work Order ID 151723

Friday, October 07, 2016 2:33:36 PM

151723

Page 1

Item ID: DSK081 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: D2940-1 Turning Detail
Start Date: 9/29/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 10/7/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan:  Date: 16-10-11 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK081	B								
100		0.02							
100	MORI SEIKI CNC LATHE LARGE								
Doosan	Memo	0.43							
Doosan Lathe	Turn blank as per Folio FA079								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.01							
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.02							
Quality Control									

6 0 16-11-19

6 0 16-11-19

B.P 16-11-20 6 0 DAS 08 9-09

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Friday, October 07, 2016 2:33:36 PM

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00				6	✓		DAS 08 9-09
Packaging	LOCATION: MAT060								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS
21
9-09

NOV 2 1 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

Picklist Print

Friday, October 07, 2016 2:33:36 PM

Page 1

Work Order ID: 151723

151723

Parent Item: DSK081

DSK081

Parent Item Name: D2940-1 Turning Detail

Start Date: 9/29/2016

Required Date: 10/7/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-007

Manufactured No

Each 14.0000

6

D6104-007

SL 1611-19

Round Billet, 17-4

Location

Loc Qty

Loc Code

MAT043

14

142433

4

149950

10

153127

6

DART AEROSPACE LTD		Work Order:	151723
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.213	3.213	3.214	3.213	3.213
B	4.946	4.966		4.960	4.961	4.956	4.956	4.956
C	0.718	0.738		.728	.728	.728	.728	.728
D	0.090	0.110		.100	.100	.100	.100	.100
E	3.564	3.584		3.573	3.574	3.574	3.574	3.574
F	0.022	0.042		.030	.032	.030	.030	.032
G	3.444	3.464		3.454	3.454	3.454	3.454	3.454
H	0.112	0.132		.121	.120	.120	.121	.121
I	2.170	2.190		2.179	2.179	2.179	2.179	2.179
J	4.451	4.471		4.461	4.461	4.461	4.461	4.461
K	0.413	0.433		.423	.423	.423	.423	.423
L	0.913	0.933		.923	.923	.923	.923	.923
M								
N								
O								
P								

Measured by: JH	Date: 16-11-19
Audited by: B.A.	Date: 16-11-20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 151723
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

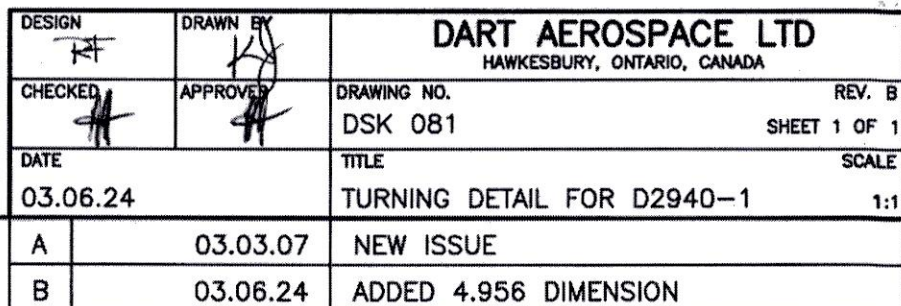
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

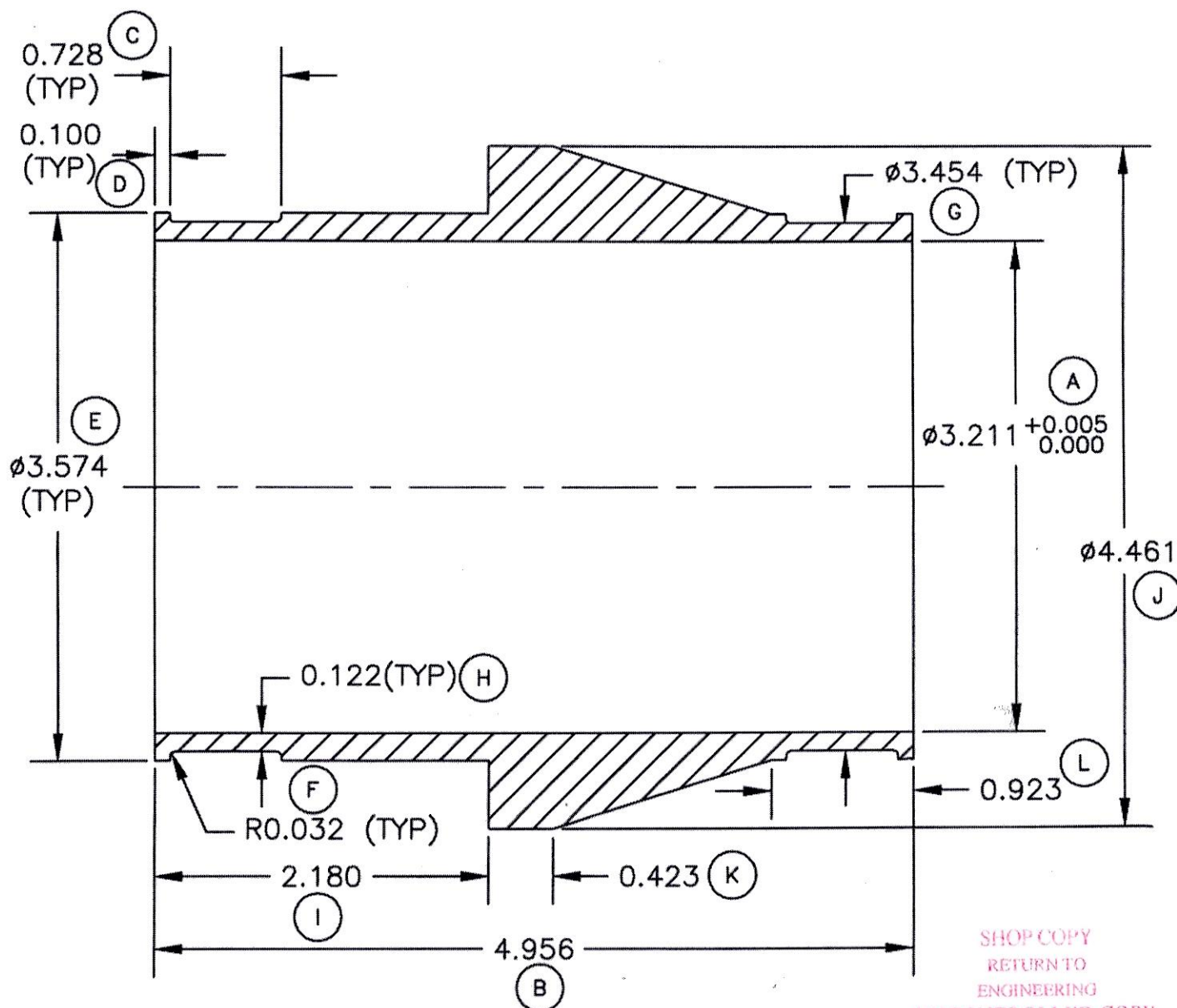
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.214				
B	4.946	4.966		4.956				
C	0.718	0.738		.728				
D	0.090	0.110		.100				
E	3.564	3.584		3.574				
F	0.022	0.042		.032				
G	3.444	3.464		3.454				
H	0.112	0.132		.120				
I	2.170	2.190		2.179				
J	4.451	4.471		4.461				
K	0.413	0.433		.423				
L	0.913	0.933		.923				
M								
N								
O								
P								

Measured by: <u>AK</u>	Date: <u>16-11-19</u>
Audited by: <u>B. C.</u>	Date: <u>16-11-20</u>
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



RELEASED
03-07-01



D2940-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151723

WORK ORDER
NO. 151723
#16-10-11

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